

Work Order ID -119939

May-30-14 8:42:05 AM

119939

Page 1

Item ID: D350-636-018

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/30/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/30/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 1405-30

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4168-044

B

m.d.

0.00

AUG 12 2014

DAS
06
9-89

MLJ

AUG 12 2014

100

Document Control

DOCUMENT CONTROL

0.00

Memo

Photocopy blue file and type labels per PPP D350-636-018 CHG 005

100

DC

Doc.Control -USB or Paperwork

FWD BEND 89.7° BE 1406-13

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Item ID: D350-636-018

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/30/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 5/30/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00

110

Skidtubes

0.00

Skidtubes

Skidtubes

Memo

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D4168

3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side.

ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE

Drill pilot holes using drill Jig DT8150 & DT8864A for first side only DT8864B for second side section BE-BE and BC-BC

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill fwd step holes using DT9616 detail AA . Ensure proper positioning.

6-Drill pilot holes for wearplates as per Dwg D4168 using DT9678. Locating from 66.54" holes.

7-Open up holes of Detail A to 0.297" (total of 2 holes per side) +.201"(total of 1 hole per side)

8-Weld D2744 Cap as per Dwg D4168 and QSI 004.Fill grooves in bend left from bending as per QSI 004

BE 14-06-13

BE 14-06-14

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Item ID: D350-636-018

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

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Start Date: 5/30/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 5/30/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

A/R Aluminum Rod batch: m129285

9-Grind welds flush as per Dwg D4168

7 BE 14-06-16

120

QC10- Inspect visual per QS1004- ground welds 0.00

120

QC

Memo

0.00

Quality Control

SMS
14/6/16

130

QC5- Inspect part completeness to step on W/O 0.00

130

QC

Memo

0.00

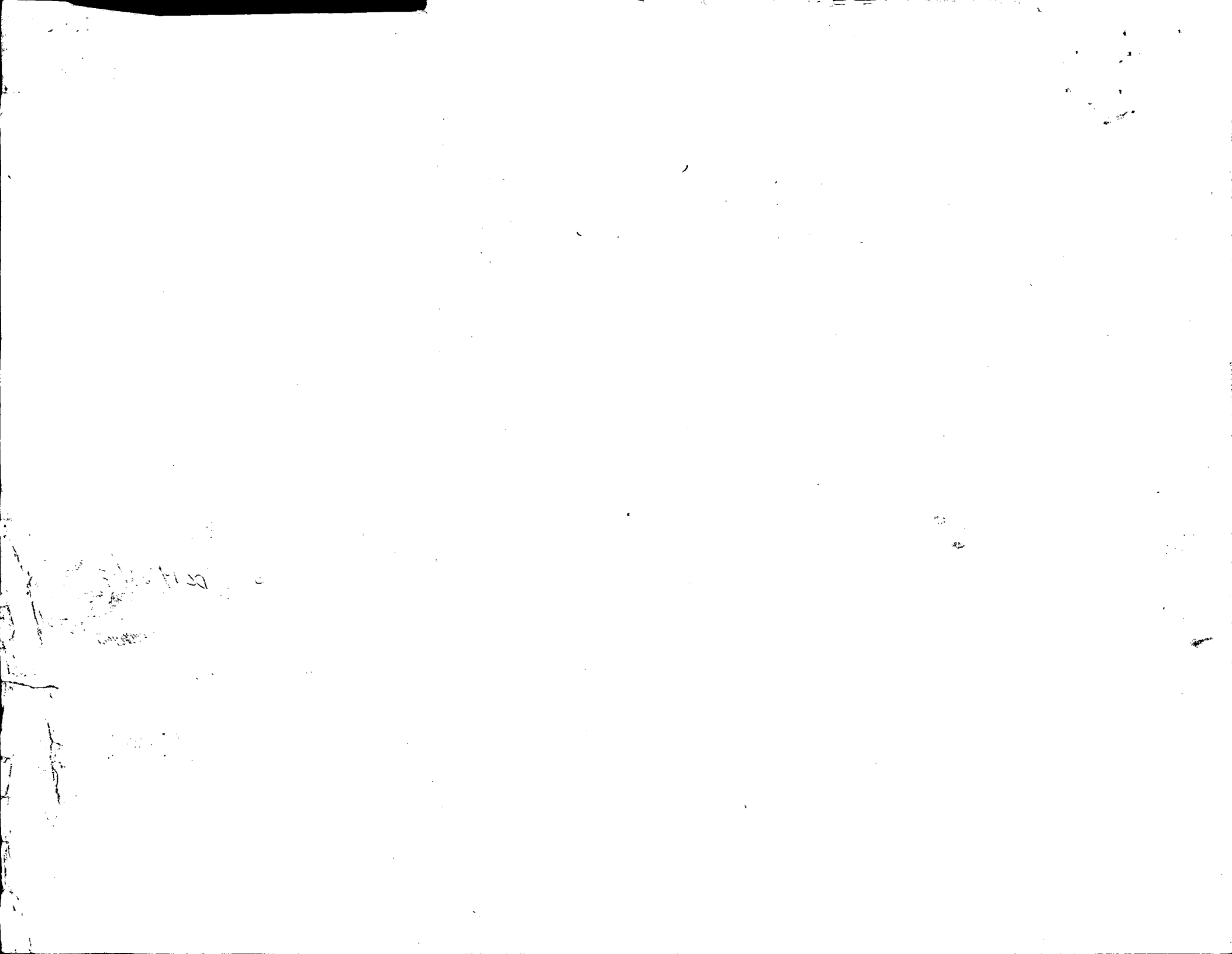
Quality Control

SMS
14/6/16

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[illegible]



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Item ID: D350-636-018

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/30/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 5/30/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Skidtubes	0.00							
160	Skidtubes								
Skidtubes	<p>Memo</p> <p>1-Open up holes using hole saw of Detail AB and ground handling to 0.625" (total of 8 holes per side) as per dwg D4168.</p> <p>2-Open up holes of wearplate holes to 0.375" section CK-CK (total of 4 holes per side) 0.3125" holes section BC-BC (4 per side) as per dwg D4168.</p> <p>3- Open float using uni-bit hole to 0.500" (4 per side)</p> <p>4-Chamfer holes dwg D4168 (welding instructions on sheet 11)</p> <p>5-Deburr and blow out all chips from inside of tube</p> <p>6- Prepare tube for welding, remove alodine as required.</p> <p>7-Bond web D2739 in place as per OSI 015 let cure for 12hrs. A/R Sikaflex-291 batch: <u>128569</u> exp. date: <u>14/11/20</u></p> <p>8- Weld spacers as per dwg D4168 & OSI004 (welding instructions on sheet 11) A/R Aluminum Rod batch: <u>m129285</u></p> <p>9- Grind welds flush as per Dwg D4168</p> <p>10-Spot face ground handling holes section (total of 4 places per side) as per dwg D4168</p>	0.00							

0219/06/17

BE14-06-19

14-6-20

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Item ID: D350-636-018 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/30/14 Start Qty: 1.00 *1* Cust Item ID:

Required Date: 5/30/14 Req'd Qty: 1.00 *1* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11- C'bore section CK-GK. ADJUST TOOLING AS REQUIRED.
VERF BY: BE

12- Deburr holes, ensure tube is free of all scratches before sending to paint.

***** FOR DELUXE SKIDTUBE IF APPLICABLE DRILL TOW RING
HOLE IN TUBE *****
*****REF TO W/O BATCH: _____*****

170 QC10- Inspect visual per QSI004- ground welds 0.00

170

QC

Quality Control

Memo

0.00

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Quality Control

Memo

0.00

14-6-23

14/6/24

14/6/24

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Item ID: D350-636-018

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Setup Start *NS1*

Revision ID:

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Start Date: 5/30/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 5/30/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190 Pressure Wash per QSI005 4.3

0.00

190

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

1 7/6/14-25

200

0.00

200

SprayPaint

Memo

0.00

Spray Painting

1- PRIME AS PER DWG AND QSI 005 4.2

PRIMER PRC DESOTO 515X349 BATCH: 128975

2- PAINT WHITE AS PER DWG AND QSI 005 4.2

PAINT BATCH: 129269

1 0 0 14-7-1

210

QC14- Inspect Spray Paint

0.00

210

QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

IRK 9/10/14 15-88

DAS

15

8-88

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Setup Start *NS1*

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Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Stop *NS2*

Start Date: 5/30/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 5/30/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	HandFinishing	0.00							
230	HandFinish	0.00							
Hand Finishing	Memo								
	1- Install inserts as per Dwg D4168								
	2-Inspect for Foreign Objects								
	3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: 1129457 EXP DATE: 11/11								
	4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: 1121651 R70 598 Bk 11125792 exp 15/10 6								
	5-Coat all exposed fasteners with "LPS Procyon" batch: 1122900								
240	QC5- Inspect part completeness to step on W/O	0.00							
240	QC	0.00							
Quality Control	Memo								

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Item ID: D350-636-018

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/30/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 5/30/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

250

Pick Kit

0.00

250

Packaging

Memo

0.00

Packaging

1/X DAS 28 9-89 AUG 12 2014 DAS 31 9-89

260

QC4- 100% Inspect kits for completeness

0.00

DAS 06 9-89

260

QC

Memo

0.00

Quality Control

*****ensure antiseize is on AN8C21A bolts*****

AUG 12 2014

270

Packaging

0.00

270

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-636-018

Location: 071

PPP rev: _____

DAS 06 9-89

AUG 12 2014

CK

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Item ID: D350-636-018

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/30/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 5/30/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00

280

QC

Memo

0.00

Quality Control

MLS 14-08-13
MLS 14-08-13

Picklist Print

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Work Order ID: 119939

119939

Parent Item: D350-636-018

D350-636-018

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/30/14

Required Date: 5/30/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev:A 10.09.28 new issue DD verf:EC IPP Rev:B
11.04.14 ecn11-553 DD verf:EC IPP Rev:C 11.10.18 as per
NCR 11-906 DD verf:EC IPP Rev:D 11.04.16 AS PER ECN 12-
542 DD verf:EC IPP REV:E 13.08.28 PER ECN13-594 DD
VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3490-1		Manufactured	No			160	Each	115.0000	4	4			
---------	--	--------------	----	--	--	-----	------	----------	---	---	--	--	--

D3490-1

Cross Bolt Spacer

**

BE14-06-18

Location	Loc Qty	Loc Code
----------	---------	----------

LG	115	
112737	1	
116358	114	

AN3C34A		Purchased	No			230	Each	32.0000	1	1			
---------	--	-----------	----	--	--	-----	------	---------	---	---	--	--	--

AN3C34A

BOLT

**

14/07/29

Location	Loc Qty	Loc Code
----------	---------	----------

ST352	32	
m127044	32	

AN3C36A		Purchased	No			230	Each	170.0000	4	4			
---------	--	-----------	----	--	--	-----	------	----------	---	---	--	--	--

AN3C36A

Bolt

**

14/07/29

Location	Loc Qty	Loc Code
----------	---------	----------

FG	25	
101261	4	
122204	11	
124827	10	
ST514	145	
m127769	5	
m128398	65	
m128773	75	

x 4

Picklist Print

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Work Order ID: 119939

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Parent Item: D350-636-018

D350-636-018

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float
Compatible

Start Date: 5/30/14

Required Date: 5/30/14

AN3C37A Purchased No

230 Each

Start Qty: 1.00
386.0000 1 1

Required Qty: 1.00

AN3C37A

BOLT

DAS
06
3-89

Location

Loc Qty

Loc Code

ST353

10

M124131

1

M127823

9

ST514

376

M128491

176

M128773

200

129687

DAS
28
9-89

AUG 12 2014

DAS
31
9-89

AN3C42A Purchased No

230 Each

40.0000 1 1

AN3C42A

Bolt

DAS
06
9-89

Location

Loc Qty

Loc Code

FG

5

121103

5

ST353

35

m127300

1

m128491

9

m128830

25

1X

DAS
28
9-89

DAS
31
9-89

D3488-042 Manufactured No

230 Each

12.0000 1 1

D3488-042

Blade Fitting RH

Location

Loc Qty

Loc Code

FP001

2

113592

1

98887

1

FP002

10

112237

10

V1

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Parent Item: D350-636-018

D350-636-018

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/30/14

Required Date: 5/30/14

D3490-5

Manufactured No

230 Each

32.0000 4 4

Start Qty: 1.00

Required Qty: 1.00

D3490-5

Cross Bolt Spacer

**

BE14 06-18

Location

Loc Qty

Loc Code

LG001

32

109104

32

D3492-1

Manufactured No

230 Each

144.0000 8 8

**

11/08/29

D3492-1

Plug

Location

Loc Qty

Loc Code

FP001

144

B119646

111578

2

112738

8

114879

134

D3492-5

Manufactured No

230 Each

129.0000 8 8

**

NIR PTO last page ->

D3492-5

Plug

Location

Loc Qty

Loc Code

FP001

129

104854

9

105612

39

112740

81

D3873-1

Manufactured No

230 Each

223.0000 7 7

**

11/02/29

D3873-1

Bushing

Location

Loc Qty

Loc Code

ST067

223

B121363

104858

5

105611

217

109110

1

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Parent Item: D350-636-018

D350-636-018

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/30/14

Required Date: 5/30/14

D4154-041

Manufactured No

230

Each

4.0000

Start Qty: 1.00

1

1

Required Qty: 1.00

D4154-041

Wearplate Assembly

**

ll 11/02/14

Location

Loc Qty

Loc Code

FP002

4

B119A23

106716

1

✓

114212

3

D4170-1

Manufactured No

230

Each

101.0000

4

4

D4170-1

Bushing

**

BE14-061B

Location

Loc Qty

Loc Code

LG001

101

107896

101

4

D4171-1

Manufactured No

230

Each

15.0000

1

1

D4171-1

Bushing

**

ll 11/07/14

Location

Loc Qty

Loc Code

ST098

15

109144

15

✓

MS21043-3

Purchased No

230

Each

528.0000

5

5

MS21043-3

Nut

**

ll 11/07/14

Location

Loc Qty

Loc Code

FG

80

103691

80

ST315

55

124555

35

m126741

20

ST509

393

m128398

393

✓

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Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/30/14

Required Date: 5/30/14

NAS1149C0363R

Purchased

No

230

Each

1,265.000

Start Qty: 1.00

9

9

Required Qty: 1.00

NAS1149C0363R

Washer

del 11/02/14

Location

Loc Qty

Loc Code

FP001

580

114742

580

Return2014

6

114742

6

ST292

679

122441

79

m128591

600

x9

NAS1515H3L

Purchased

No

230

Each

483.0000

4

4

***NAS1515H3I ***

Washer

del 11/02/14

Location

Loc Qty

Loc Code

FG

40

102472

40

ST297

443

m127831

159

m128976

284

x4

NAS1611-005

Purchased

No

230

Each

171.0000

8

8

NAS1611-005

O-RING

10/14 1270 huct page 7

Location

Loc Qty

Loc Code

FP001

171

m126974

96

m129198

75

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Parent Item: D350-636-018

D350-636-018

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/30/14

Required Date: 5/30/14

NAS1611-010

Purchased

No

230

Each

Start Qty: 1.00
195.0000 8 8

Required Qty: 1.00

NAS1611-010

O-RING

**

SS 10/07/14

Location

Loc Qty

Loc Code

FP001

195

1129523

x 0

m126988

3

m127813

4

m128375

80

m128388

8

m129198

100

NAS1149D0863J

Purchased

No

250

Each

859.0000 2 2

NAS1149D0863J

Washer

**

DAS
28
9-89

AUG 12 2014

DAS
31
9-89

Location

Loc Qty

Loc Code

FP001

2

118078

2

ST293

57

125484

57

ST510a

800

125268

600

125635

200

D2744

Manufactured

No

110

Each

21.0000 1 1

D2744

Cap

**

BE 406-16

Location

Loc Qty

Loc Code

LG001

21

115440

21

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Parent Item: D350-636-018

D350-636-018

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float
Compatible

Start Date: 5/30/14

Required Date: 5/30/14

D2600-3-BENT

Manufactured No

110 Each

Start Qty: 1.00
8.0000 1 1

Required Qty: 1.00

D2600-3-BENT

Extrusion Bent

**

BE14-06-12
B120571 x1

Location Loc Qty Loc Code

LG	7	
117904	7	
LG002	1	
112976	1	

D2743

Manufactured No

160 Each

124.0000 8 8

D2743

Crossbolt Spacer

**

BE14-06-18

Location Loc Qty Loc Code

LG	123	
111570	8	
112729	115	
LG001	1	
109799	1	

D2739

Manufactured No

160 Each

12.0000 1 1

D2739

350 I Beam

**

DE14/06/17

Location Loc Qty Loc Code

LG	5	
111094	1	
113252	1	
117803	3	
LG002	7	
115881	7	

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119939

Parent Item: D350-636-018

D350-636-018

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/30/14

Required Date: 5/30/14

AN6C44A

Purchased

No

230

Each

Start Qty: 1.00
127.0000 4 4

Required Qty: 1.00

AN6C44A

Bolt

**

ll 11/07/29

Location

Loc Qty

Loc Code

FG

2

103964

2

ST341

28

m128319

28

v4

ST505

97

m128700

47

m129199

50

MS21083C8

Purchased

No

230

Each

161.0000 1 1

MS21083C8

Nut

**

ll 11/07/29

Location

Loc Qty

Loc Code

ST319

11

m127255

5

m128119

6

ST508

150

m128798

150

x1

D3631-1

Manufactured

No

230

Each

180.0000 8 8

D3631-1

Washer

**

ll 11/07/29

Location

Loc Qty

Loc Code

FP001

180

110258

16

111019

12

115800

52

119553

100

v8

Picklist Print

Page 10

May-30-14 8:42:08 AM

Work Order ID: 119939

119939

Parent Item: D350-636-018

D350-636-018

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float
Compatible

Start Date: 5/30/14

Required Date: 5/30/14

NAS1149C0332R

Purchased

No

230

Each

Start Qty: 1.00
5,700.000 4 4

Required Qty: 1.00

NAS1149C0332R

WASHER

**

lll 11/07/24

Location

Loc Qty

Loc Code

GA

825

125654

825

11129909

✓

Return2014

41

122063

41

ST292

1676

124580

8

125654

8

m128591

1660

st510

3158

m126319

61

m127306

2500

m127410

563

m127831

34

D2745

Manufactured

No

230

Each

78.0000 8 8

D2745

Bushing

**

lll 11/07/24

Location

Loc Qty

Loc Code

ST017

78

107336

4

111554

8

113176

58

90323

2

93336

6

B117099

✓

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Shop Packet Print

Page 10

Picklist Print

May-30-14 8:42:08 AM

Page 11

Work Order ID: 119939

119939

Parent Item: D350-636-018

D350-636-018

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/30/14

Required Date: 5/30/14

NAS1149C0832R

Purchased

No

230

Each

Start Qty: 1.00
290.0000 1 1

Required Qty: 1.00

NAS1149C0832R

Washer

**

lll 11/07/14

Location

Loc Qty

Loc Code

ST292

290

122441

23

m114915

117

m125807

150

x1

AN3C6A

Purchased

No

230

Each

1,265.000 4 4

AN3C6A

Bolt

**

lll 11/07/14

Location

Loc Qty

Loc Code

FG

10

122416

10

ST351

2

m128224

2

ST513

1253

m125709

257

m128769

996

x4

MS21043-6

Purchased

No

230

Each

218.0000 4 4

MS21043-6

NUT

**

lll 11/07/14

Location

Loc Qty

Loc Code

FG

20

103693

20

ST315

10

m127255

10

ST509

188

m127813

188

x4

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Shop Packet Print

Page 11

Picklist Print

May-30-14 8:42:09 AM

Page 12

Work Order ID: 119939

119939

Parent Item: D350-636-018

D350-636-018

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/30/14

Required Date: 5/30/14

D3493-1	Manufactured	No	250	Each	199.0000	2	2	Start Qty: 1.00	Required Qty: 1.00
D3493-1								**	
Washer									DAS 28 9-89

13
3
39

Location	Loc Qty	Loc Code
FG	10	
97201	10	
ST051	189	
109105	159	
112741	30	

DAS 31 9-89

MS21083C8	Purchased	No	250	Each	161.0000	2	2	Start Qty: 1.00	Required Qty: 1.00
MS21083C8								**	
Nut									DAS 28 9-89

DAS 06 9-89

Location	Loc Qty	Loc Code
ST319	11	
m127255	5	
m128119	6	
ST508	150	
m128798	150	

DAS 31 9-89

AN8C21A	Purchased	No	250	Each	49.0000	2	2	Start Qty: 1.00	Required Qty: 1.00
AN8C21A								**	
Bolt									DAS 28 9-89

DAS 06 9-89

Location	Loc Qty	Loc Code
ST	2	
123966	2	
ST341	2	
m127061	2	
ST342	3	
m128319	2	
m128849	1	
ST508	42	
m127823	42	

DAS 31 9-89

May-30-14 8:42:09 AM

Shop Packet Print

Page 12

May-30-14 8:42:09 AM

Work Order ID: 119939

119939

Parent Item: D350-636-018

D350-636-018

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float
Compatible

Start Date: 5/30/14

Required Date: 5/30/14

D2741

Manufactured No

250

Each

34.0000

Start Qty: 1.00

Required Qty: 1.00

D2741

Blade

DAS

AUG 12 2014

28
9-89

Location

Loc Qty

Loc Code

FG	14
100664	5
115522	5
98323	4
FP001	1
88824	1
ST466	19
107206	2
113640	12
115522	5

118387

DAS
31
9-89

DAS
86
9-89

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D4168-041	350 SKIDTUBE ASSEMBLY, LH
	X			D4168-042	350 SKIDTUBE ASSEMBLY, RH
		X		D4168-043	350 SKIDTUBE ASSEMBLY, LH
			X	D4168-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
8	8	8	8	D3631-1	WASHER
7	7	7	7	D3873-1	BUSHING
1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
1				D4168-1	SKIDTUBE WELDMENT, LH
	1			D4168-2	SKIDTUBE WELDMENT, RH
		1		D4168-3	SKIDTUBE WELDMENT, LH
			1	D4168-4	SKIDTUBE WELDMENT, RH
4	4	4	4	D4170-1	SPACER
1	1	1	1	D4171-1	BUSHING
4	4	4	4	ALS4-1032-225	INSERT
4	4	4	4	AN3C6A	BOLT
1	1	1	1	AN3C34A	BOLT
4	4	4	4	AN3C36A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
9	9	9	9	AN960C10	WASHER (OR NAS1149CO363R)
4	4	4	4	AN960C10L	WASHER (OR NAS1149CO332R)
1	1	1	1	AN960C816L	WASHER (OR NAS1149CO832R)
5	5	5	5	MS21043-3	NUT
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

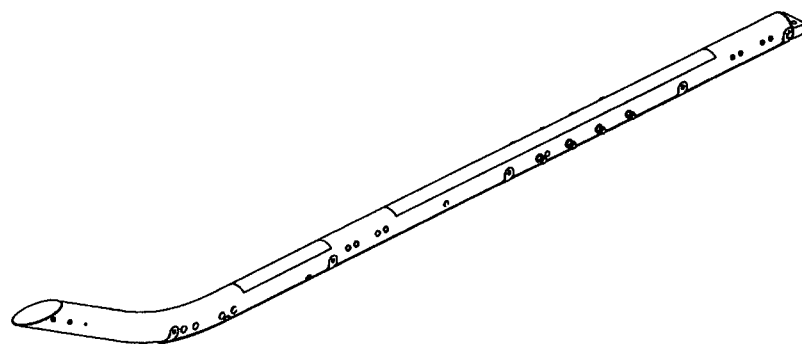
- MATERIAL: MAKE D4168-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D4168-041/-042/-043/-044 = 32.3 LBS
- WELD PER DART QSI 004
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 119939 MJS
14-05-30

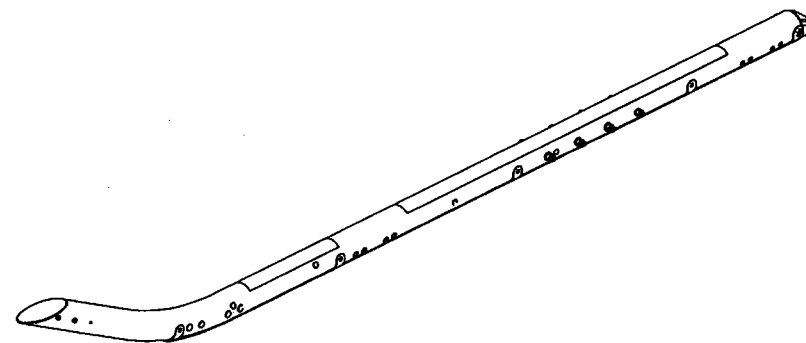
RELEASED
2013-08-13
AMP

B	ADD VIEW TO CONTROL FWD BEND ORIENTATION (2N D-1-4/-5/-6/-7); UPDATED FINISH OPTIONS. REASON: PARTS-276 AND NCR13-2737	MB	13.07.11
A	NEW ISSUE	SC	10.08.09
REV.	DESCRIPTION	BY	DATE
DESIGN	SC		
DRAWN	SC		
CHECKED	SC		
MFG. APPR.	SC		
APPROVED	SC		
DE APPR.	SC		
DATE	13.07.11		

DART AEROSPACE USA, INC. KENT, WA	
DRAWING NO. D4168	REV. B
TITLE 350 SKIDTUBE ASSEMBLY	SHEET 1 OF 11
SCALE NTS	
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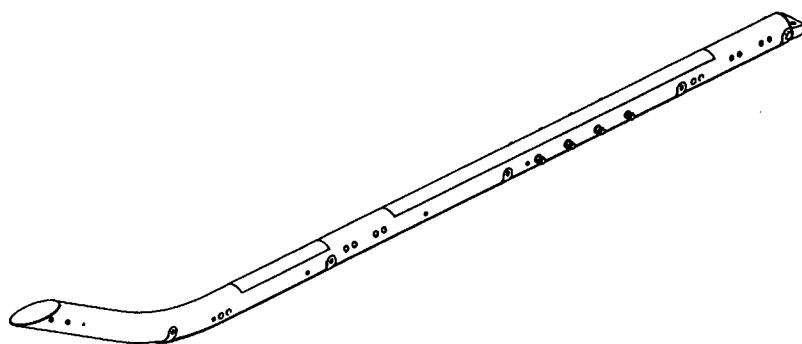
D4168-041 350 SKIDTUBE ASSEMBLY, LH



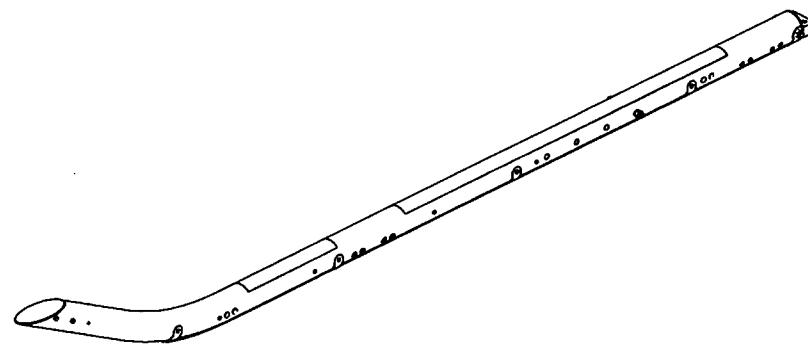
D4168-042 350 SKIDTUBE ASSEMBLY, RH

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DRAWN	<i>[Signature]</i>	
CHECKED	<i>[Signature]</i>	
MFG. APPR.	<i>[Signature]</i>	
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DE APPR.		REV. B
DATE	13.07.11	SHEET 2 OF 11
		SCALE NTS



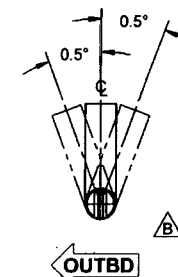
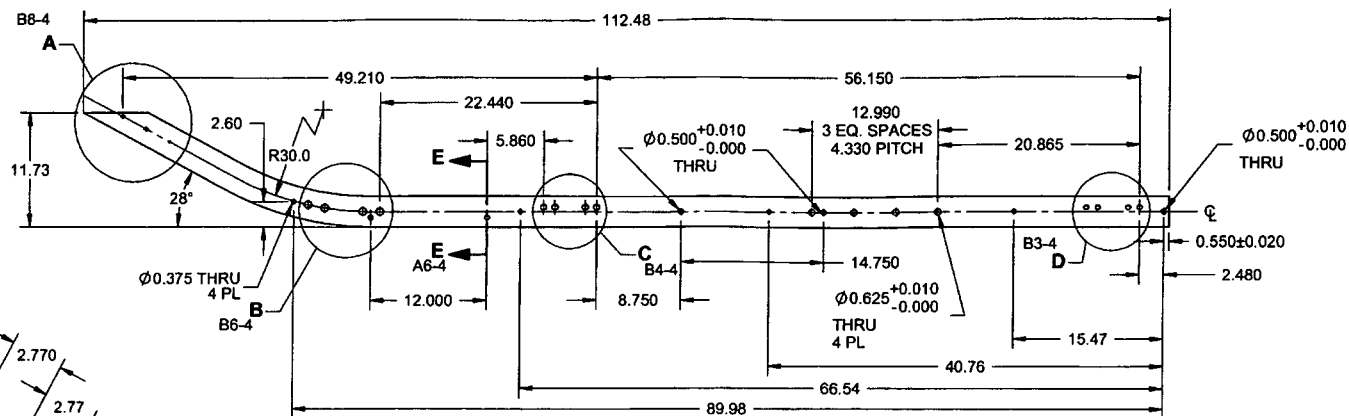
D4168-043 350 SKIDTUBE ASSEMBLY, LH



D4168-044 350 SKIDTUBE ASSEMBLY, RH

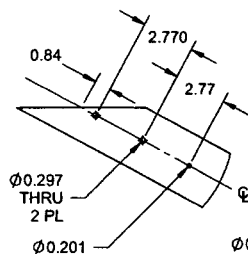
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MFG. APPR.	JP	D4168	SHEET 3 OF 11
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	350 SKIDTUBE ASSEMBLY	NTS
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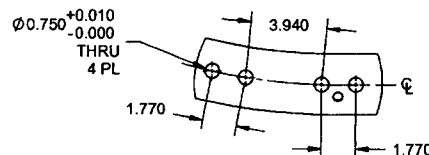


MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)

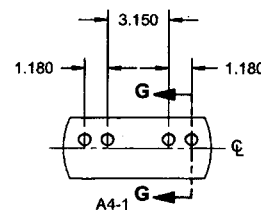
D4168-1 LH SKIDTUBE



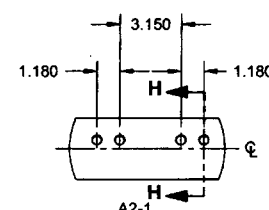
DETAIL A
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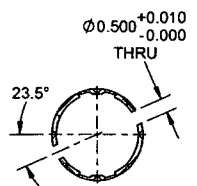
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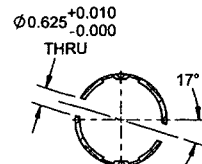
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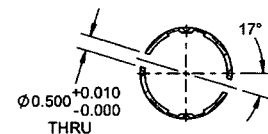
DETAIL D
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SECTION E-E
SCALE 3X, 2 PL



SECTION G-G
SCALE 3X, 4 PL



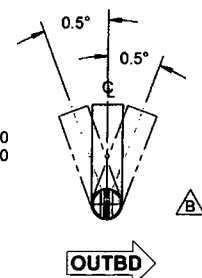
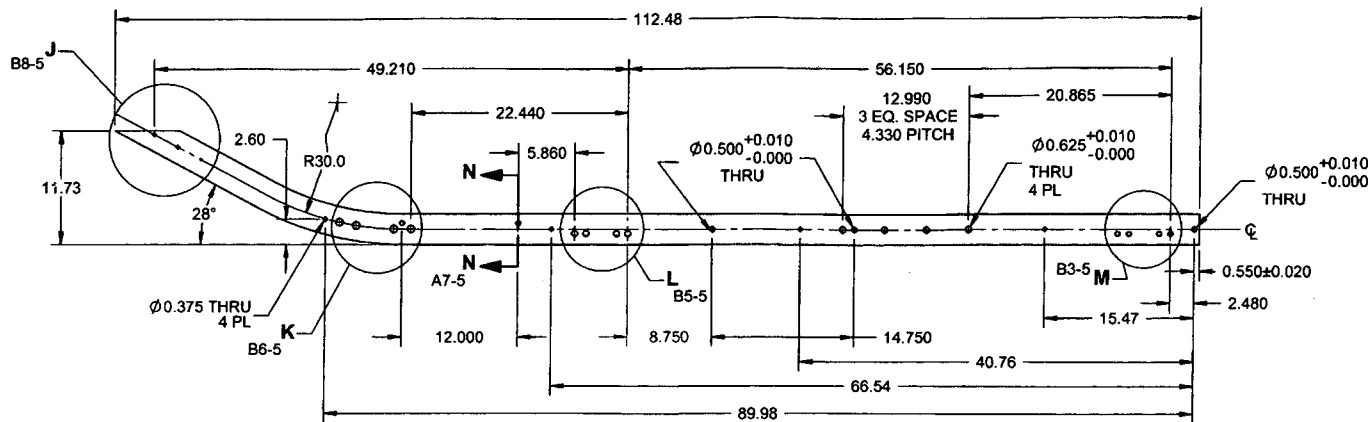
SECTION H-H
SCALE 3X, 4 PL

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APPROVED
DE APPR.
DATE 13.07.11

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KENT, WA

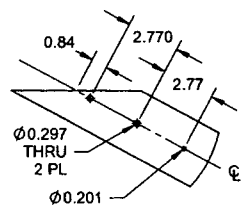
DRAWING NO. **D4168**
TITLE **350 SKIDTUBE ASSEMBLY**
REV. A
SHEET 4 OF 11
SCALE
NTS
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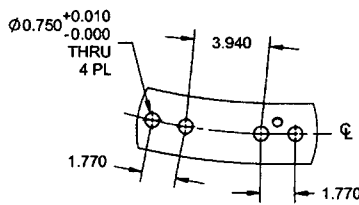


MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)

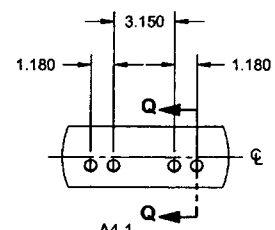
D4168-2 RH SKIDTUBE



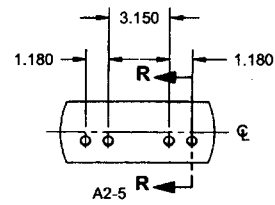
DETAIL J
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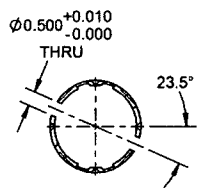
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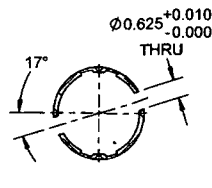
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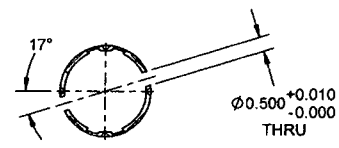
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SECTION N-N
SCALE 3X, 2 PL



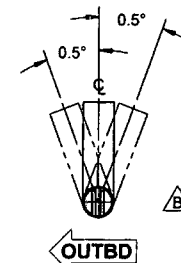
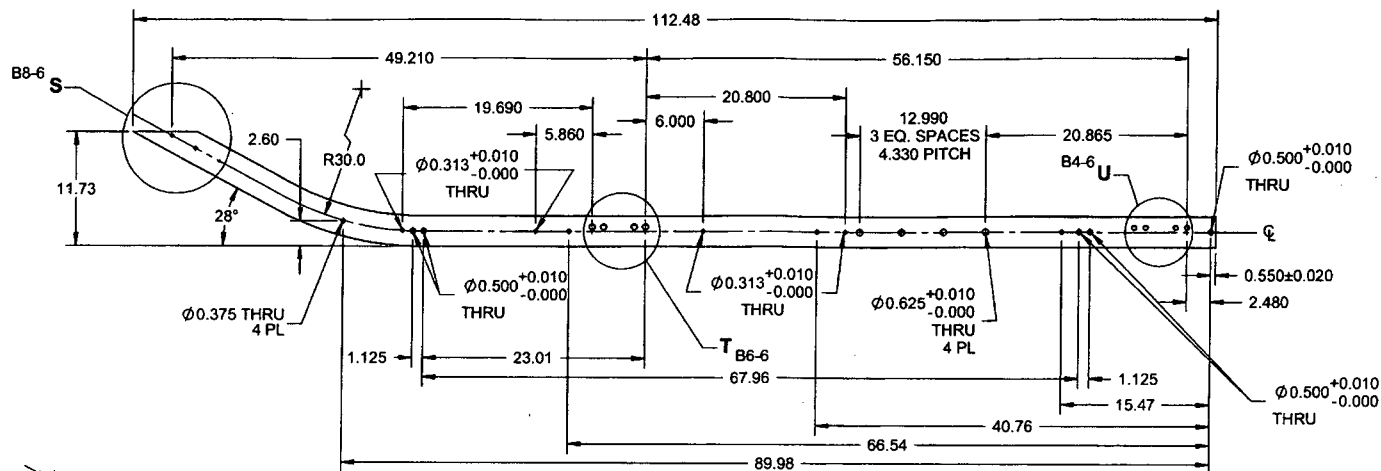
SECTION Q-Q
SCALE 3X, 4 PL



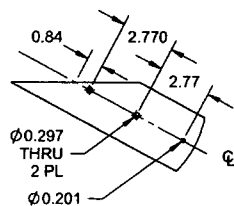
SECTION R-R
SCALE 3X, 4 PL

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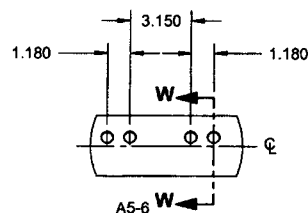
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DRAWN		KENT, WA	
CHECKED		DRAWING NO. D4168	
MFG. APPR.		REV. B	
APPROVED		SHEET 5 OF 11	
DE APPR.		SCALE NTS	
DATE 13.07.11		TITLE 350 SKIDTUBE ASSEMBLY	
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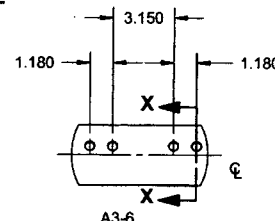
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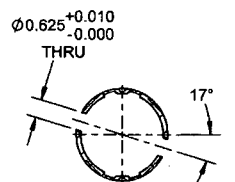
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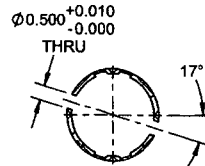
DETAIL T
SCALE 2X



DETAIL U
SCALE 2X



SECTION W-W
SCALE 3X, 4 PL

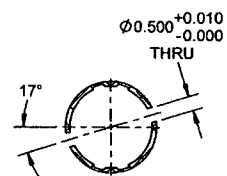
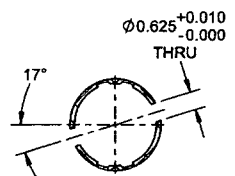
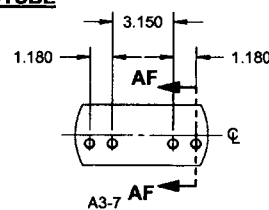
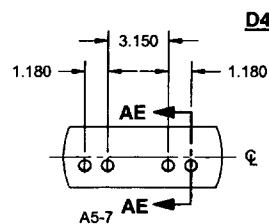
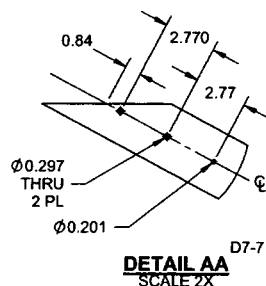
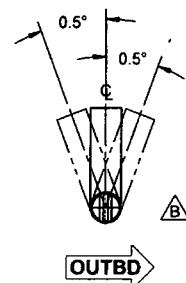
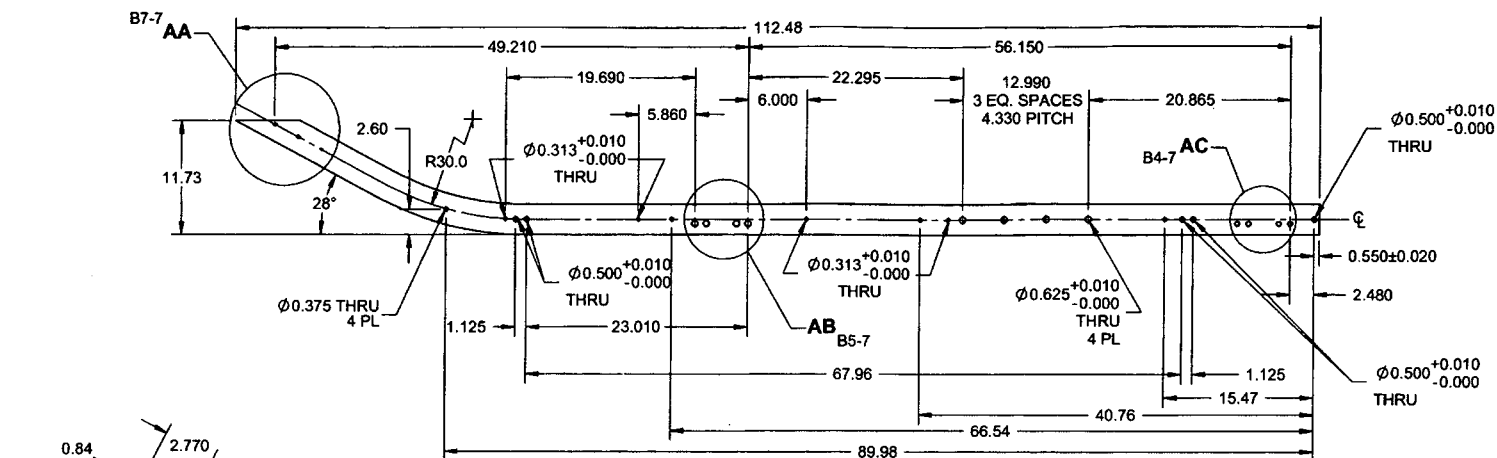


SECTION X-X
SCALE 3X, 4 PL

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2013-08-13
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MFG. APPR.	<i>[Signature]</i>	
APPROVED	<i>[Signature]</i>	
DE APPR.		REV. B
DATE	13.07.11	SHEET 6 OF 11
		SCALE NTS

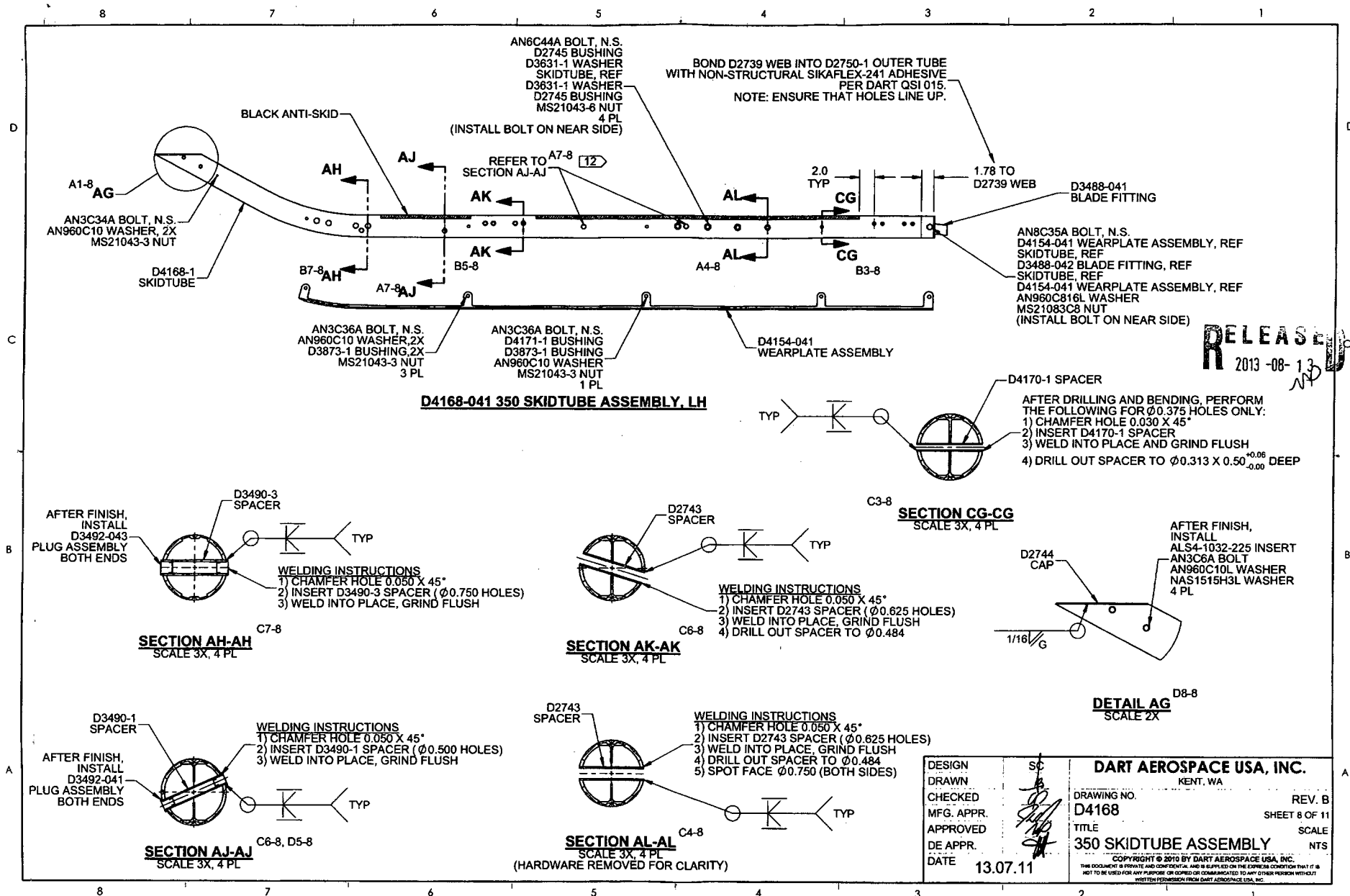
8 7 6 5 4 3 2 1



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DATE	13.07.11	SHEET 7 OF 11
		SCALE NTS

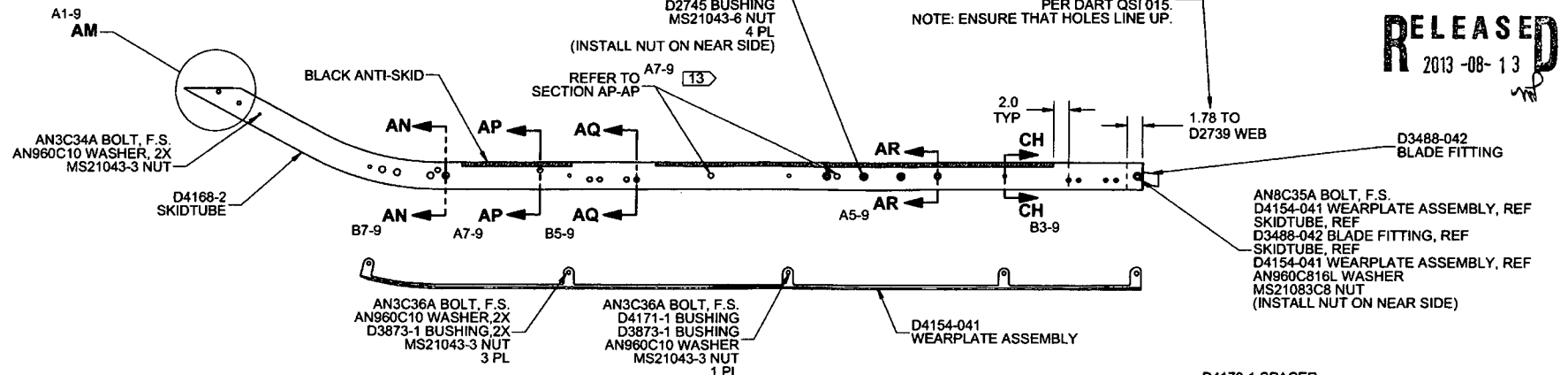
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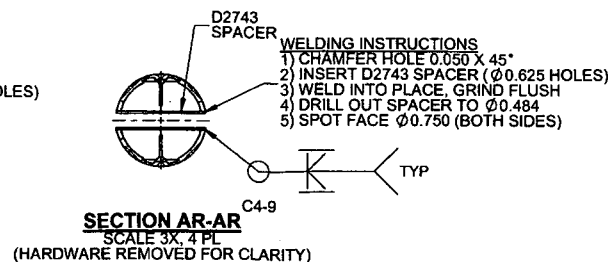
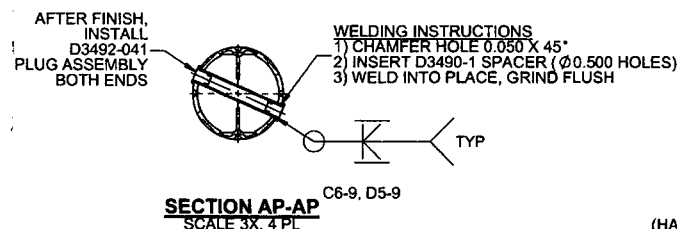
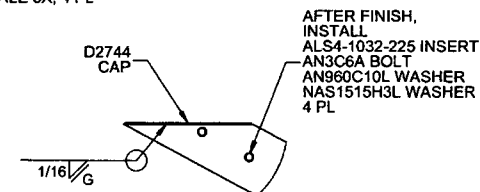
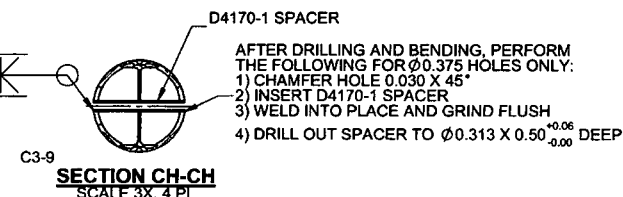
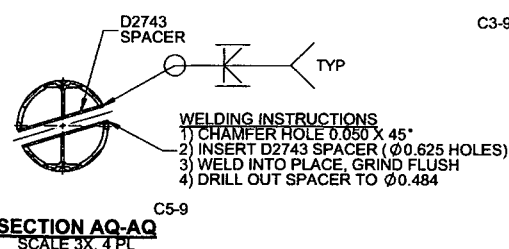
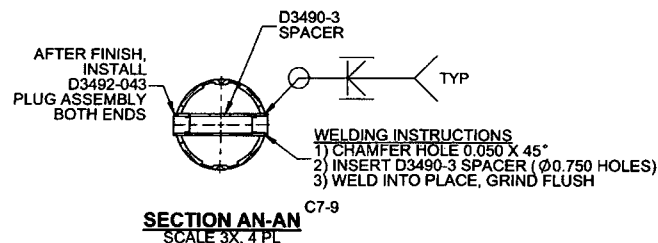
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AN6C44A BOLT, F.S.
D2745 BUSHING
D3631-1 WASHER
SKIDTUBE, REF
D3631-1 WASHER
D2745 BUSHING
MS21043-6 NUT
4 PL
(INSTALL NUT ON NEAR SIDE)

BOND D2739 WEB INTO D2750-2 OUTER TUBE
WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE
PER DART QSI 015
NOTE: ENSURE THAT HOLES LINE UP.



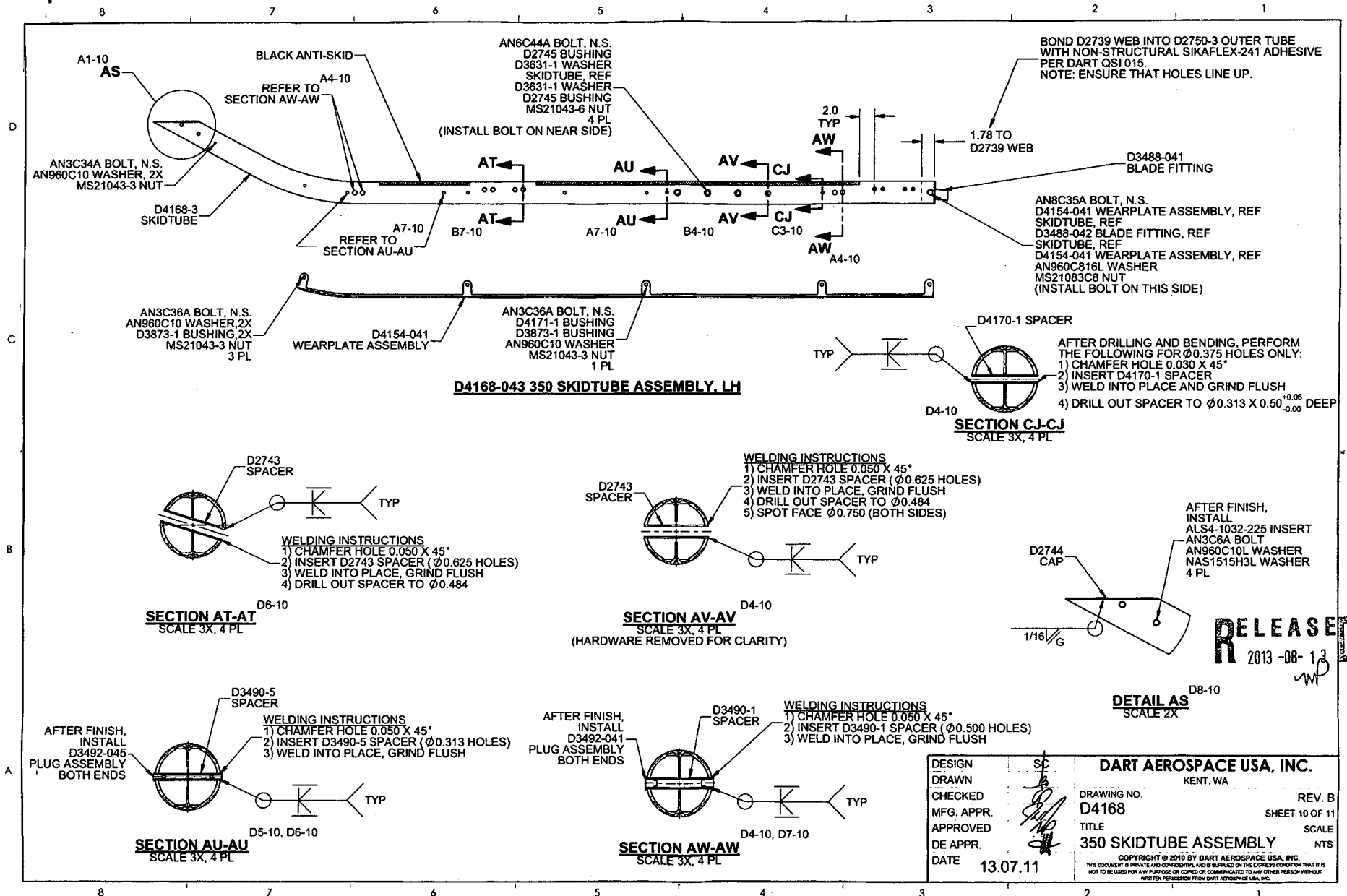
D4168-042 350 SKIDTUBE ASSEMBLY, RH



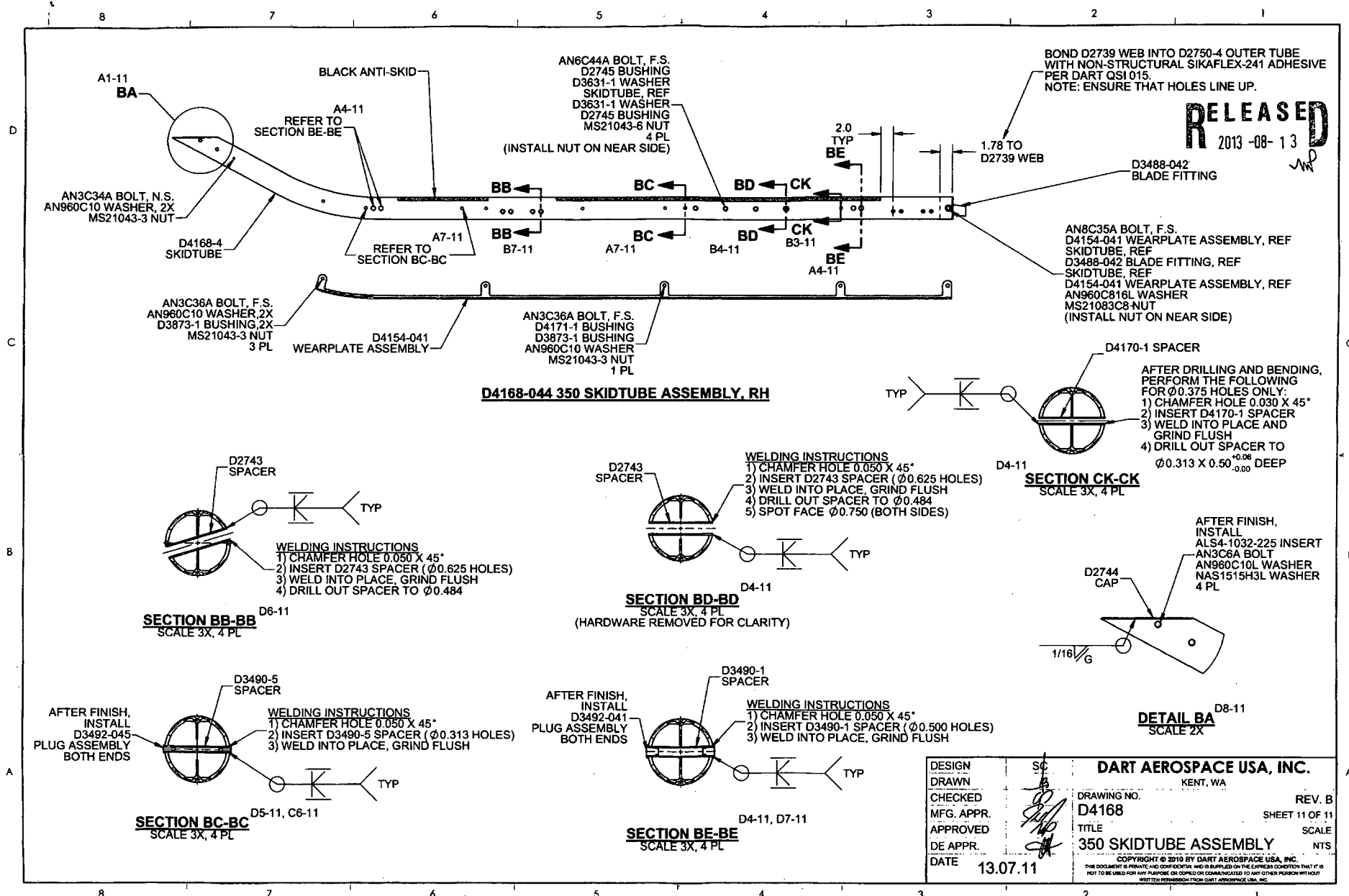
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TITLE 350 SKIDTUBE ASSEMBLY
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SHEET 9 OF 11
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Linda Lacelle

From: David Shepherd
Sent: June-24-14 1:00 AM
To: Chris Provencal
Cc: Mike Petsche; Linda Lacelle
Subject: RE: plugs on skidtubes

Chris,

Sorry for the delay in getting back to you on this.

If these are the only plugs that we are having a problem with, then I am OK with leaving them out of the skidtubes since the holes that are being plugged are so small. Seems weird to me that we've suddenly started to have a problem, but whatever.

Can I assume from your email that the rest of the plugs are OK?

Regards,
David

From: Chris Provencal
Sent: June-04-14 10:59 AM
To: David Shepherd
Cc: Mike Petsche
Subject: RE: plugs on skidtubes

David,

When installing D3492-045 plugs into the 3/16" holes for D4168-043 Skidtubes (AS 350), the o-rings are ripping. See the attached photos for one of the plugs. The effected hole is section AU-AU from the attached pdf page. This is causing some of the plugs to fall out when handling them.

I tried a new plug (D3492-5) and new o-ring (NAS1611-005) with an unpainted D3890-5 spacer (0.197 ID) and could not get it installed without the same ripping. We enlarged a spacer to 0.206" ID and put a 0.220"x45deg c'sink (about the OD of the o-ring) hoping it would force the o-ring into the hole. It ripped less, but the o-ring just doesn't want to compress that much. Some of the o-ring always wants to squeeze out and it gets sheared off when you try to force the plug in (it takes a lot of force to get it in).

I don't know how we've been doing this in the past. We only noticed the problem this time during final packaging of the latest batch.

le

PAR 14-338

~~SECRET~~

Patrick Smith
May-29-14 1:29 PM
Linda Lacelle; Mike Petsche
Nigel Forbes; Eric Downing; Nancy MacLeod; David Shepherd
RE: 350 skids and 206 skids

David and he would allow us to use a RTV product to bond the Plugs into the Skidtube.

Plugs would require:
oval from the Skidtube
oval of the current O-Ring
ning with Alcohol
allation of NEW O-Ring
erous coating of the RTV
rtion of plug into the Spacer
in up of exterior of Skidtube.

a Lacelle
29-14 10:21 AM
tsche
rbes; Patrick Smith; Eric Downing; Nancy MacLeod
50 skids and 206 skids
e: High

terday that plugs were falling out. Today we were told that we cannot ship any 350 skids. We have an order to ship today, has there been a solution
this problem? Can we not just sikaflex them in or something? We need to let the customer know if his order is shipping or not...

